

Work Order ID 148638

Thursday, July 07, 2016 12:53:06 PM

148638

Page 1

Item ID: D3954-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gwt Knob

Start Date: 8/5/2016 Start Qty: 6.00

6

Cust Item ID:

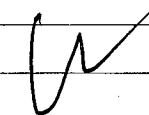
Required Date: 8/10/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: 

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3954

D

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3854

Dwg Rev: DProg Rev: D

2-Deburr if necessary

0.16

on 11/6/08/09

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.01

on 11/6/08/09

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Run	Start	*NR1*
	Stop	*NR2*

[illegible]

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Page 3

Item ID: D3954-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gwt Knob
 Start Date: 8/5/2016 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 8/10/2016 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: STG3	0.00				6	PL		
170									
Packaging	Memo	0.01	DAS 6 9-89						AUG 18 2016
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.10					DAS 21 9-89		AUG 18 2016
Quality Control									

**DAS
21
9-89** **AUG 18 2016**

Picklist Print

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Work Order ID: 148638

148638

Parent Item: D3954-3

D3954-3

Parent Item Name: Gwt Knob

Start Date: 8/5/2016

Required Date: 8/10/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 11.08.16 AS PER REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.375X03.000		Purchased	No			100	f	6.1000	0.02778 0.166	0.175453 1.00			

M304B0 375X03 000

M304 SS bar .375 x 3.00

**

pc 16/08/09

Location

Loc Qty

Loc Code

MAT

6.1

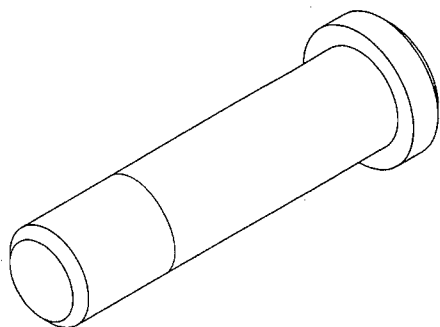
m132876

0.4

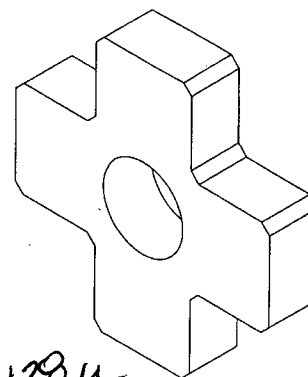
m134696

5.7

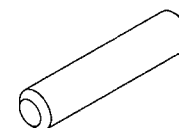
1.2



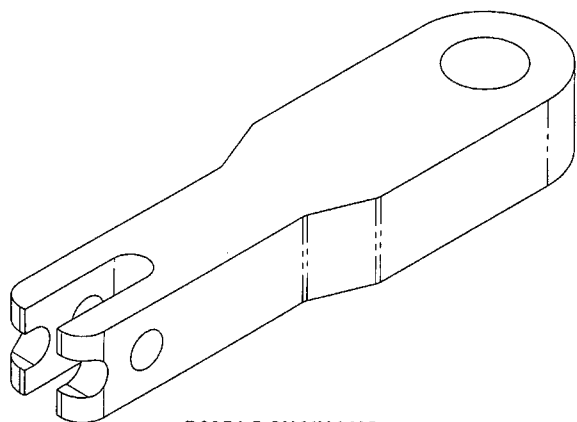
D3954-1 GWT PIN



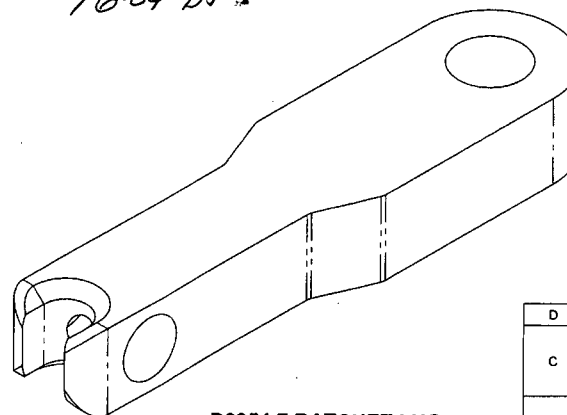
D3954-3 GWT KNOB



D3954-9 GWT CHAIN PIN



D3954-5 CHAIN LUG



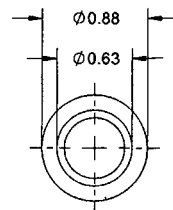
D3954-7 RATCHET LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171362

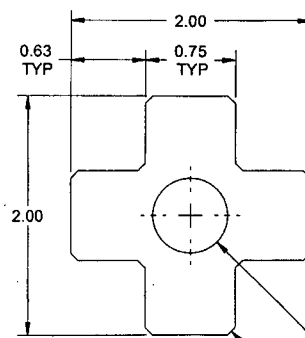
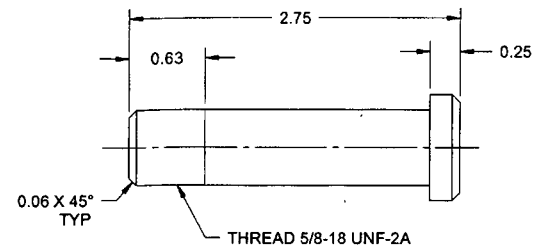
ML5
1607 DT

RELEASED
2012-10-01

D	ZN A6-2, A6-3. REVISED NOTE 2 TO ADD POWDER COAT.	DC	12.08.10
C	MATERIAL UPDATE FOR D3954-1/-3: NOW STAINLESS STEEL ONLY (A6-2); FINISH CHANGED TO "NONE" FOR D3954-1/-3 (A6-2); TOLERANCE ON Ø0.750 WAS Ø0.75 MAX (D3-3 & D7-3); D3954-9 NOW A PURCHASED PART (A2/A6-3). REASON: PAR11-113.	MB	11.07.27
B	MATERIAL UPDATE FOR ALL COMPONENTS WAS STAINLESS STEEL IS CARBON STEEL FOR ALL COMPONENTS. FINISH FOR ALL COMPONENTS WAS RED POWDER COAT IS YELLOW SPRAY PAINT.	AJS	09.10.15
A	NEW ISSUE	AJS	09.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS/DSTOW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3954 REV. D SHEET 1 OF 3 TITLE SCALE MISC MACHINED PARTS GWT KIT NTS COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DRAWN	DC		
CHECKED	AS		
MFG. APPR.	AS		
APPROVED	MD		
DE APPR.	N/A		
DATE	12.08.10		

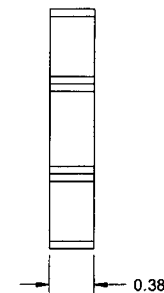


D3954-1 GWT PIN



D3954-3 GWT KNOB

THREAD 5/8-18 UNF-2B THRU
0.06 X 45° TYP

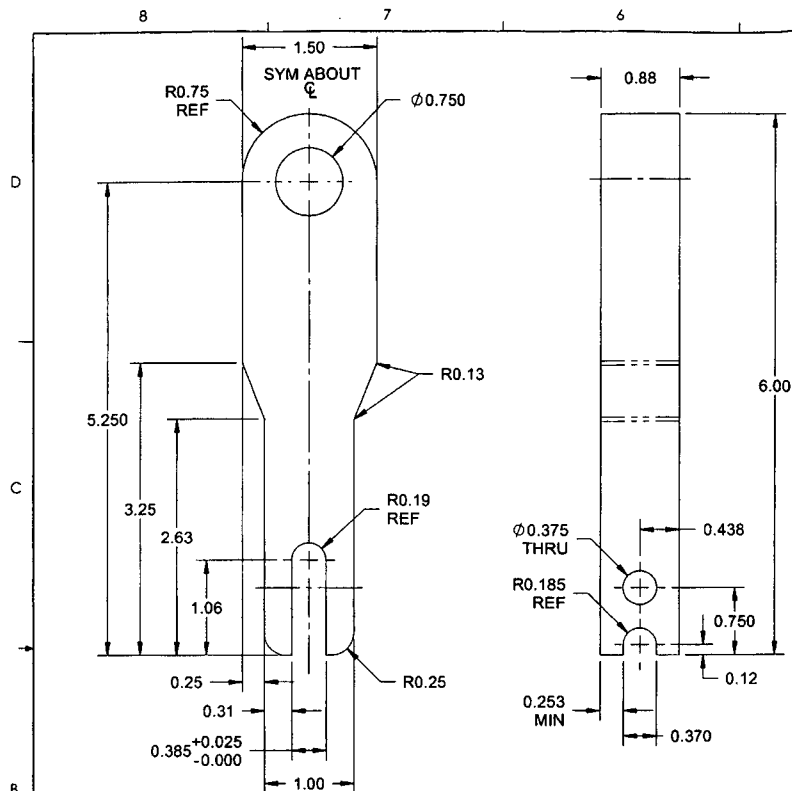


NOTES:

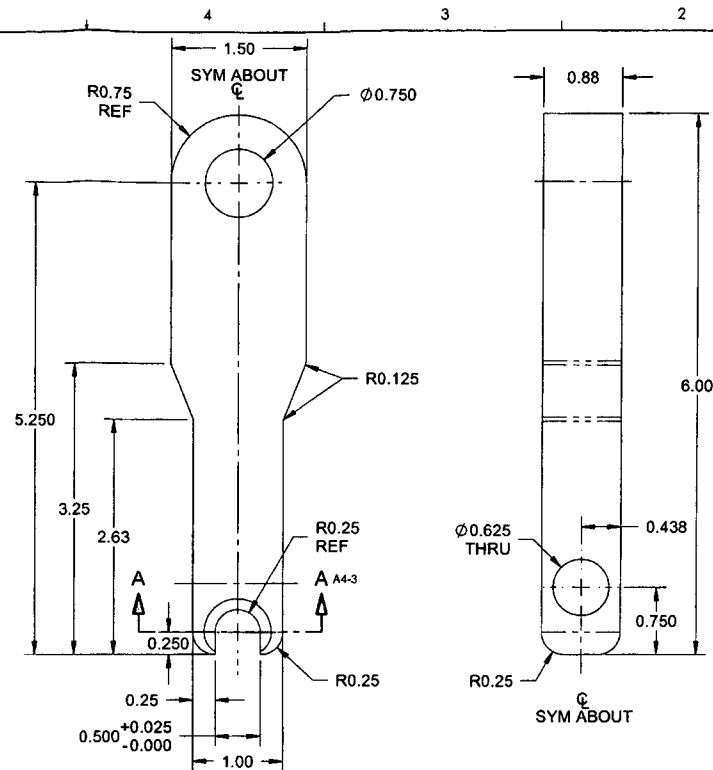
- 1) MATERIAL -1: AISI 303/304/316 STAINLESS STEEL ROUND BAR
PER ASTM A582 (303) OR ASTM A276 (304/316)
REF DART SPEC M303R OR M304R
-3: AISI 303/304/316 STAINLESS STEEL SHEET
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M303S OR M304S
OR:
AISI 303/304/316 STAINLESS STEEL BAR OR AISI 304/316 PLATE
PER ASTM A582 (303) OR A276 (304/316) OR ASTM A240 (304/316)
REF DART SPEC M303B OR M304B
- 2) FINISH: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2
OR POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3 $\triangle$
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT -1: 0.26 lbs
-3: 0.23 lbs

RELEASED
2012-10-01

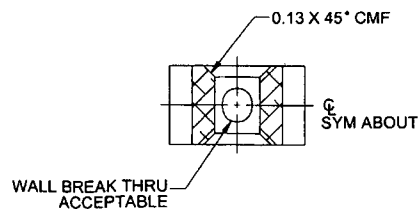
DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. D
MFG. APPR.	DC	D3954	SHEET 2 OF 3
APPROVED	DC	TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
DATE	12.08.10	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



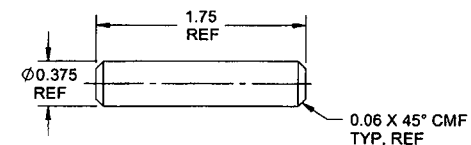
D3954-5 CHAIN LUG



D3954-7 RATCHET LUG



SECTION A-A C3-3



D3954-9 GWT CHAIN PIN

NOTES:

1) MATERIAL:

-5/-7: AISI 1010-1025 MILD STEEL BAR

PER DART SPEC M1010-B

-9: PURCHASE PART FROM MCMASTER-CARR:

P/N 98381A630 (MILD STEEL)

ALTERNATE MATERIAL:

-5/-7: AISI 303/304/316 STAINLESS STEEL BAR OR AISI 304/316 PLATE

PER ASTM A582 (303) OR A276 (304/316) OR ASTM A240 (304/316)

REF DART SPEC M303B OR M304B

-9: PURCHASE PART FROM MCMASTER-CARR:

P/N 90145A630 (STAINLESS STEEL)

2) FINISH -7 ONLY: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2

OR POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1

7) WEIGHT -5/-7: 1.56 lbs EACH

-9: 0.05 lbs REF

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BE	DRAWING NO.	REV. D
MFG. APPR.	JK	D3954	SHEET 3 OF 3
APPROVED	MD	TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
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R 2012-10-01

